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005300

D119-646-314
Job Sheet 181777



Part No: D119-646-314

Job Qty: 2 ea

Part Name: Skidtube Protector, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/8/18

Job Tracking No:

Due Date: 11/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.12.10 NEW ISSUE DD VERF:JLM IPP REV:B 17.05.10 AS PER DSI9734 REV B
DD VERF:JFS IPP REV:C 17.08.16 AS PER DSI9734 REV C DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/1/18	11/1/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 04 2018
110	Packaging	2 pcs	11/1/18	11/1/18	0.00	0.00	Packaging1-1		SEP 21 2018
120	QC	2 pcs	11/1/18	11/1/18	0.00	0.00	QC4		SEP 21 2018
130	Packaging	2 pcs	11/1/18	11/1/18	0.00	0.00	Packaging3-1		SEP 21 2018
135	DC	2 pcs	11/1/18	11/1/18	0.00	0.00	DC		SEP 21 2018
140	QC21-FG	2 Ea	11/1/18	11/1/18	0.00	0.00	QC21		SEP 21 2018

Part Op 130 - Identify and pack for shipping as per PPP D119-646-314 Location:
Descriptions: 135 - Photocopy bluefile & type labels per PPP D119-646-314 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-45A	Bolt	8 Ea (4 ea)	90-Start up Operation	5093618
AN3-47A	Bolt	12 Ea (6 ea)	90-Start up Operation	5084129
AN3-50A	Bolt	12 Ea (6 ea)	90-Start up Operation	5093754
D3904-1	Washer	12 Ea (6 ea)	90-Start up Operation	5055204
D4506-3	Washer	12 Ea (6 ea)	90-Start up Operation	5098709
D5369-2	Cable Guard	2 Ea (1 ea)	90-Start up Operation	5052224
D5371-2	Hook	2 Ea (1 ea)	90-Start up Operation	5097211
D5372-1	Plug	2 Ea (1 ea)	90-Start up Operation	5090035
D5374-1	Bushing	12 Ea (6 ea)	90-Start up Operation	5100391
D5374-3	Bushing	16 Ea (8 ea)	90-Start up Operation	5096646
D5376-1	Drilling Tool	2 Ea (1 ea)	90-Start up Operation	5089850
MS21042L3	Nut	20 Ea (10 ea)	90-Start up Operation	5089340
NAS1149D0332J	Washer	36 Ea (18 ea)	90-Start up Operation	5100402
NAS1149D0316J	Washer	8 Ea (4 ea)	90-Start up Operation	FM134502-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-45A	8	33	0
	AN3-47A	12	38	0
	AN3-50A	12	67	0
	D3904-1	12	101	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td>☐</td> <td style="width:15%;">Cross tube</td><td>☐</td> <td style="width:15%;">Water Jet</td><td>☐</td> <td style="width:15%;">Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Thermoforming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Large Fab</td><td>☐</td> <td>Composite</td><td>☐</td> <td></td><td></td> <td></td><td></td> </tr> </table>						Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Large Fab	☐	Composite	☐				
Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐																																		
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Large Fab	☐	Composite	☐																																						
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval																																			
Description Work Order Deviation																																									
Dart Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON L8A 1K7 CANADA TEL: 905 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S107769 Part: D119-646-314 Job No: 181777 Serial No/ Batch: S107769 Revision: C Inspector: Exp Date: Instructions: FAA STC SR02024SE 1518/2016 STC LoA P.																																									
Completed By																																									
Lead hand / Supervisor Approval Verification																																									
QC / QA Coordinator Approval																																									
Positioned Wrong																																									
Outside Dimensions																																									
Over/Under tolerance																																									
Part Incorrect																																									
Part Lost/Missing																																									
Part Moved																																									
Drawing																																									
Finish																																									
Misread																																									
Turning Sequence																																									

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

D4506-3	12	7	0
D5369-2	2	9	0
D5371-2	2	1	0
D5372-1	2	11	0
D5374-1	12	2	0
D5374-3	16	32	0
D5376-1	2	8	0
MS21042L3	20	4,394	0
NAS1149D0316J	8	605	0
NAS1149D0332J	36	891	0

Part Specifications

Specifications could not be found.

Plex 8/8/18 12:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

10.0 PARTS LIST:

Qty. -313	Qty. -314	PART NUMBER	DESCRIPTION
X		D119-646-313	SKIDTUBE PROTECTOR, LH
	X	D119-646-314	SKIDTUBE PROTECTOR, RH
6	6	D3904-1	WASHER
6	6	D4506-3	WASHER
1		D5369-1	CABLE GUARD, LH
	1	D5369-2	CABLE GUARD, RH
1		D5371-1	HOOK, LH
	1	D5371-2	HOOK, RH
1	1	D5372-1	PLUG
6	6	D5374-1	BUSHING
8	8	D5374-3	BUSHING
1	1	D5376-1	DRILLING JIG
4	4	AN3-45A	BOLT
6	6	AN3-47A	BOLT
6	6	AN3-50A	BOLT
18	18	NAS1149D0332J	WASHER
4	4	NAS1149D0316J	WASHER
10	10	MS21042L3	NUT

11.0 WEIGHT AND BALANCE

The following weight and balance changes are applicable:

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-313 SKIDTUBE PROTECTOR, LH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.3 m	465 in-lb 8.4 kg-m	-43.4 in 1.7 m	-187 in-lb -3.3 kg-m
D119-646-314 SKIDTUBE PROTECTOR, RH ON STANDARD SKIDTUBE	4.3 lb 1.95 kg	108.1 in 4.30 m	465 in-lb 8.4 kg-m	43.4 in 1.7 m	187 in-lb 3.3 kg-m
△ D119-646-313 SKIDTUBE PROTECTOR, LH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	-43.4 in -1.7 in	69 in-lb 1.2 kg-in
△ D119-646-314 SKIDTUBE PROTECTOR, RH ON FLOAT SKIDTUBE	1.6 lb 0.72 kg	133.3 in 3.38 m	213 in-lb 2.4 kg-m	43.4 in 1.7 in	69 in-lb 1.2 kg-in

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9734	SHEET 8 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE PROTECTOR KIT	NTS
DATE	17.06.27	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	